

Work Order ID 64004

Tuesday, November 23, 2010 9:27:46 AM



Page 1

Item ID: D3502-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Support					
Start Date: 11/22/2010	Start Qty: 10.00		Cust Item ID:		
Required Date: 12/15/2010	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>11</u>	Date: <u>10-11-23</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3502	Rev B								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 3.475 " long <input type="checkbox"/> 1 BLANK MAKES 2 PARTS								

11 10/12/20

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Mill as per Folio FA649 Rev: <u>AA</u> & Dwg D3502 Rev: <u>13</u> <input type="checkbox"/> 2-Debur								
	per dwg D3502								

OK 11/01/11

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

OK 11/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3502-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 11/22/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 12/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

52 11/01/11

Memo

0.00

(10)

140



Small Fab

Small Fab

Small Fab

Memo

Mark hole position using DT9430 Drill as per Dwg D3502.

0.00

0.00

EP 11/01/12 (10)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10 BR 11-01-13

W/O:		WORK ORDER CHANGES					
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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

White Gloss(Ref:4.3.5.1) per OSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:00

□ OVEN TEMPERATURE:

320°

□ FINISH TIME:

11:30

10. BR 11-01-13.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 0 11/01/13

180

Identify as per dwg & Stock Location: 063

0.00



Packaging

Memo

0.00

Packaging

11/10/14 (10)

W/O:		WORK ORDER CHANGES					
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Required Date: 12/15/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/14

Q 11-2-14

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Picklist Print

Tuesday, November 23, 2010 9:27:50 AM

Page 1

Work Order ID: 64004



Parent Item: D3502-1



Parent Item Name: Support

Start Date: 11/22/2010

Required Date: 12/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-07-06 JLM
IPP Rev:B Add tooling hole 07-03-28
Esr rev C added DT9430 08.11.03 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased	No			100	f	56.3995	0.289	3.042105			



6061-T6 Bar 1.00 x 4.00



SL 10/12/20

Location

Loc Qty

Loc Code

MAT03

56.3995

107221

48.3937

114352

8.0058

3.1

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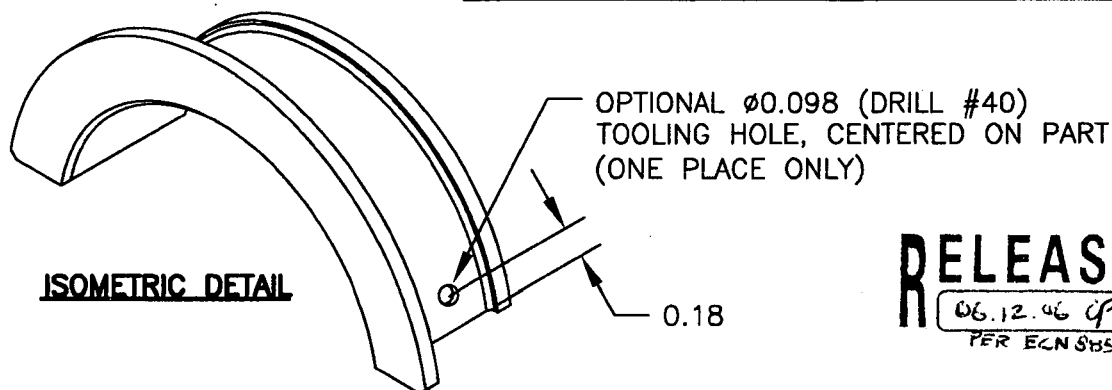
SHOP COPY
RETURN TO
ENGINEER

DART

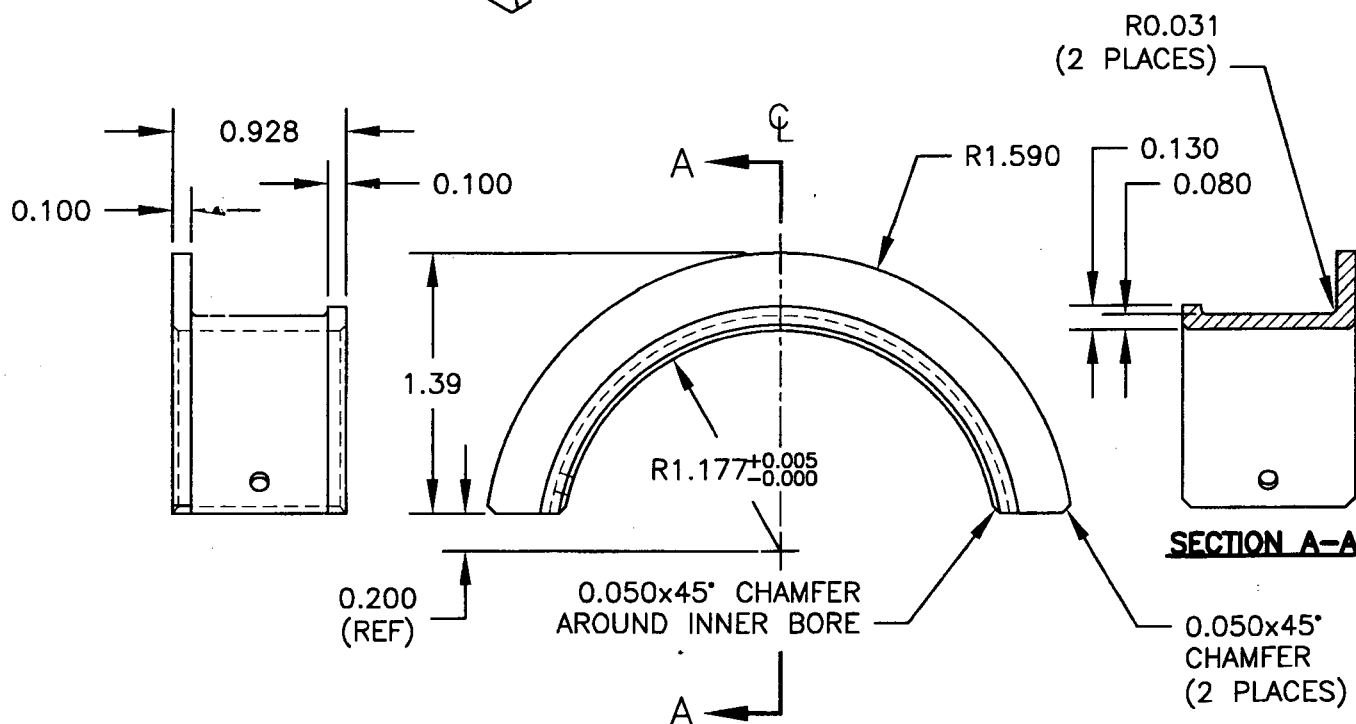
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 04004 PS-10-11-23

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3502	REV. B SHEET 1 OF 1
DATE 06.10.31		TITLE SUPPORT	SCALE 1:1
A	06.04.18	NEW ISSUE	
B	06.10.31	ADD TOOLING HOLE FOR FINISHING	



RELEASED
06.12.06 *qp*
PER ECN 885



D3502-1 SUPPORT

- 1) MATERIAL: 6061-T6 ROUND BAR (REF DART SPEC. M6061T6R)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010 , X.XX = ± 0.030) UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3

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